

Date: Thursday, 02/04/2009 2:28:37 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 46880	
Estimate Number : 12901	
P.O. Number :	Part Number : D350811
This Issue : 02/04/2009 S.O. No. :	Drawing Number : D3508 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 40398	Material :
Written By :	Due Date : 14/04/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 09.04.03</u>	
Comment : Est Rev:A New Issue 07.06.12 EC	
Est Rev:B Rev C dwg 07-12-06 DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.6181 sf(s)/Unit Total : 3.7088 sf(s)
 304SS .038" THK (20GA)
 (M304S20GA)
 Batch: 110076

ML 09 04 07

⑥

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3508
 Dwg Rev: C
 Prog Rev: C

2-Deburr if necessary

ML 09 04 07

⑥

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 09 04 07

⑥

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

PS 04 08 06

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 1-Form on brake using DT8326 and DT8261 as per Dwg D3508

PS 09/04/09 ⑥

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:28:37 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 46880

Part Number: D350811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/09 (X6)

7.0

POWDER COATING

POWDER COATING



m109648



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

12:30

OVEN TEMPERATURE:

320°

FINISH TIME:

1:00

FL 09/04/09

6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PR 09-04-9 6

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FR-16

PR 09-04-9 6

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



NLF 09 04 09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4680
Description: Wearplate		Part Number: D3508-11
Inspection Dwg: D3508	Rev: C	Page 1 of 1

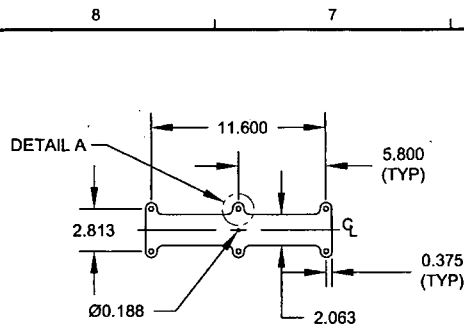
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

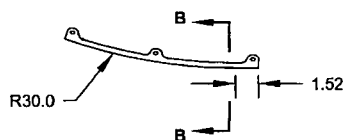
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.069	✓		vern	
2.813	+/-0.010	2.813	✓		vern	
0.375	+/-0.010	0.375	✓		vern	
5.625	+/-0.010	5.625	✓		vern	
22.500	+/-0.010	22.500	✓		M.T	
26.50	+/-0.030	26.50	✓		M.T	
Ø0.188	+0.005/-0.001	0.190	✓		vern	
0.300	+/-0.010	0.303	✓		vern	
0.300	+/-0.010	0.303	✓		vern	
0.038	+/-0.010	0.039	✓		vern	

Measured by: M.M	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09.04.07	Date: 16.04.08	Date:	N/A

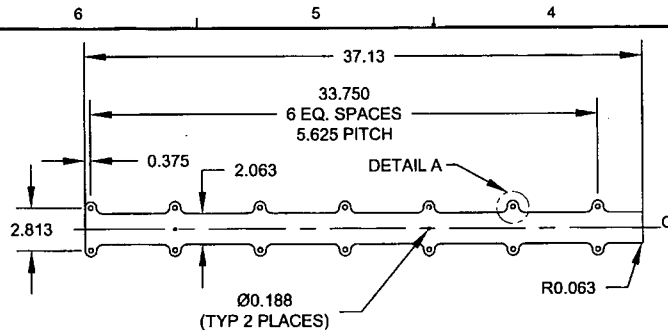
Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD [Signature]	[Signature]



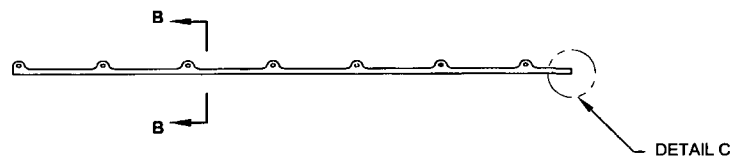
D3508-1 FLAT PATTERN



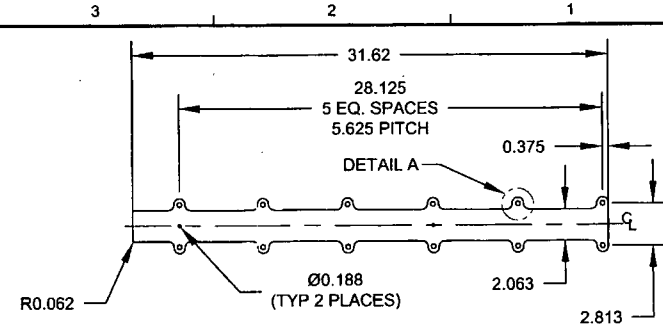
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



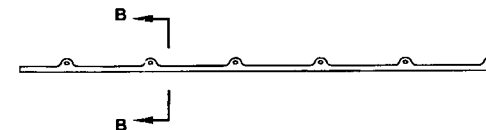
D3508-3 FLAT PATTERN



D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



D3508-5 FLAT PATTERN

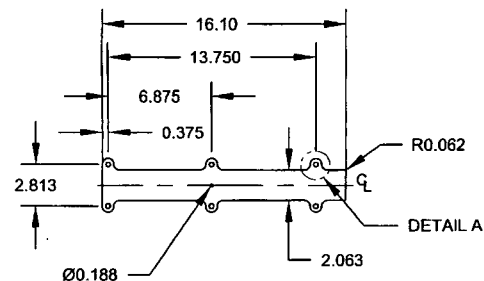


D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

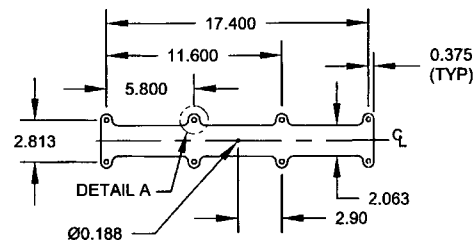
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

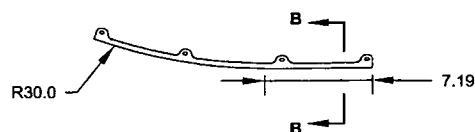
RELEASED
07-11-16



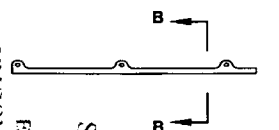
D3508-7F FLAT PATTERN



D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)

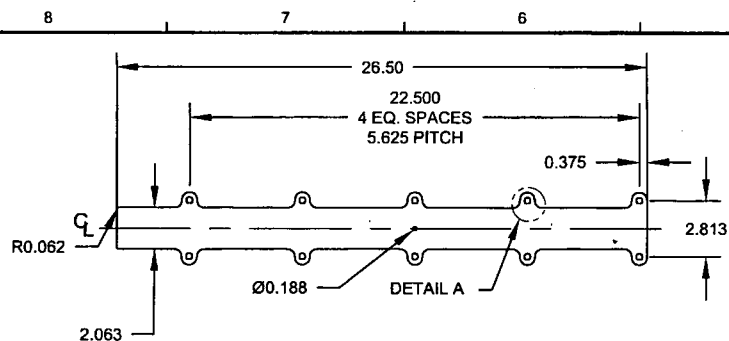
C	ADD -9/11-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	20		
DRAWN	24		
CHECKED	10		
MFG. APPR.	10		
APPROVED	10		
DE APPR.	10		
DATE	07.04.20		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

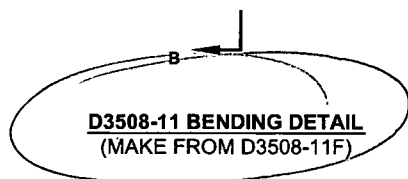
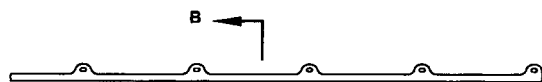
DRAWING NO. D3508
TITLE WEARPLATE
SCALE 1:8
REV. C
SHEET 1 OF 2

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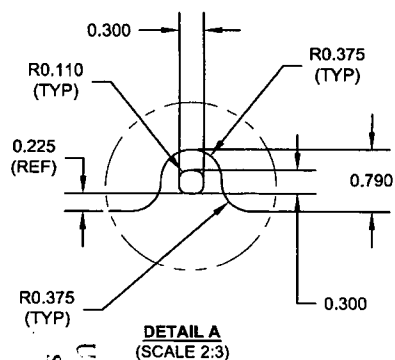
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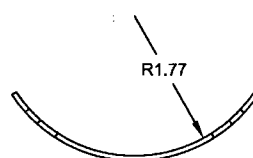
D3508-11F FLAT PATTERN



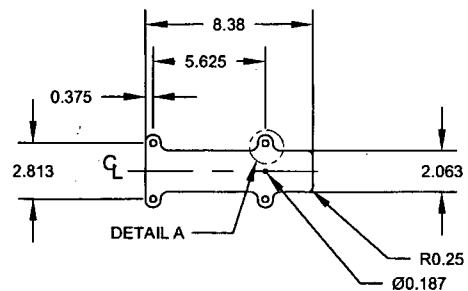
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



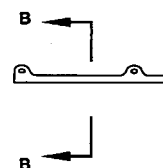
DETAIL A
(SCALE 2:3)



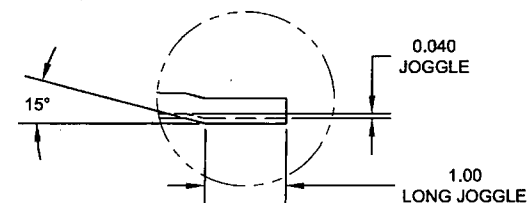
SECTION B-B
(SCALE 2:3)



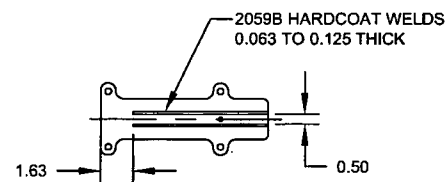
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:6
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